

# Work Order ID 52434

September 23, 2009 2:44:55 PM

Page 1

Item ID: PB67-43001-147  
 Revision ID: B1 C 09.09.24  
 Item Name: PB67-43001-147

Accept

Setup Start

Stop

Start Date: 09/24/2009 Start Qty: 400  
 Required Date: 10/02/2009 Req'd Qty: 400

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF Date: 09-09-23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-147	Rev B1 C 09.09.24

100	FLOW WATER JET	0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg B67-43001-147 <input type="checkbox"/> Dwg Rev: C <input type="checkbox"/> Prog								
	Rev: C <input type="checkbox"/> 2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
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QC	Memo	0.00							
Quality Control									

PTC

B 9-9-09

7

B 9-9-09

7

09.09.24

#100: BG7-43001-147 SHOULD BE ON ~~WORK ORDER ID~~ ITS OWN  
WORK ORDER. CREATE BG7-43001-147 AND UPDATE WORK  
ORDER BG7-43001-67 ACCORDINGLY. / 09.07.24

W/O: 52434

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-05-29	W/O	B67-43001-147 should be it's own w/o. Create B67-43001-147 & update accordingly, including an FAI sheet. * See back of previous page by Marc.B. perm change	MF	09-10-08	27	05-05-29	05-05-29

Part No: PB67-43001-147 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Work Order ID 52434

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Page 2

Item ID: PB67-43001-67

Accept

Revision ID: B1 C 09/09/09

Item Name: PB67-43001-67

Setup Start

Stop

Start Date: 09/24/2009 Start Qty: 4.00

Required Date: 10/02/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

Small Fab

Memo

0.00

0.00

SB 09/10/02

27

0

Small Fab

Form as per dwg B67-43001

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 09/10/02

427

0

150



Large Fab

Large Fab

Large Fab

Memo

Weld assembly as per dwg B67-43001

0.00

0.00

# Work Order ID 52434

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Page 3

Item ID: PB67-43001-~~67~~ 147  
Revision ID: ~~B1~~ C ~~09.09.24~~  
Item Name: PB67-43001-~~67~~ 147

Accept

Setup Start

Stop

Start Date: 09/24/2009 Start Qty: 4.00  
Required Date: 10/02/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00 0.00							
170 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
180 Small Fab Small Fab Small Fab	Small Fab  Memo Assemble as per dwg B67-43001	0.00 0.00							

N/A  
2

# Work Order ID 52434

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Page 4

Item ID: PB67-43001-~~67~~ 147  
Revision ID: B1 C ~~09.09.28~~  
Item Name: PB67-43001-~~67~~ 147

Accept

Setup Start

Stop

Start Date: 09/24/2009 Start Qty: 4.00  
Required Date: 10/02/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
200 Packaging Packaging	Identify as per dwg & Stock Location: <del>ST</del> Memo	0.00  0.00							
210 QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

NIA

09.10.05

27

09/10/05

Close at 27

cr. New w/o for PB67-43001-147

MF 09-10-06 and pull 27 x 67 on new w/o # 5263

# Picklist Print

September 23, 2009 2:44:54 PM

Page 1

Work Order ID: 52434

Parent Item: PB67-43001-67 Rev C

Parent Item Name: PB67-43001-67 147 109.09.29

Comments:

Start Date: 09/24/2009

Required Date: 10/02/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased	No			150	sf	119.2200	2.5027	4.377	①	
6061-T6 .090 Sheet											109-9-29	

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

119.22

108595

1.41

109184

20.72

111382

96

19295

1.09

MS20426AD3-4

Purchased

No

100

Each

8,221.000

48.0000

RIVET

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

8221

104374

4221

110398

4000

PB67-43001-147

B #

x .

N/A

PTO →

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-10-02	130	Pull from stock the remaining Qty 20 PB67-4300-1-147 B 41510 from stock to bend on this W/O. Make inv. adjust- ment & I.D with new B# <i>Not a perin change</i>				<i>[Signature]</i> 09-10-02	<i>[Signature]</i> 09-10-02	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/01		- Pull 20 x PB67-43001-147 from stock. <del>these not</del> <i>These were closed</i> <del>Bent</del> <i>but not bent.</i>		<del>Bent like Dwg</del> <i>rev c</i>				
		<del>MF B# 41510</del> <i>09-10-01</i>						

NOTE: Date & initial all entries



# Picklist Print

September 23, 2009 2:44:54 PM

Work Order ID: 52434

Parent Item: PB67-43001-67RevB1

Parent Item Name: PB67-43001-67

Comments:

Start Date: 09/24/2009

Required Date: 10/02/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21075L3

Purchased

No

180

Each

275.0000

24.0000



Nutplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

275

109068

12

109371

39

110704

37

111477

2

112640

20

112690

165

PB67-43001-149RevB1

Manufactured

No

180

Each

25.0000

8.0000



Side Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

25

40025

1

41560

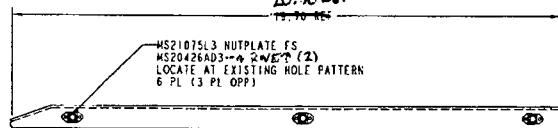
24

NIA  
7



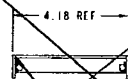
# 52434

N/A

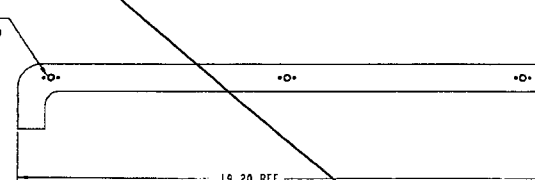
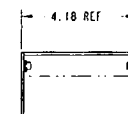
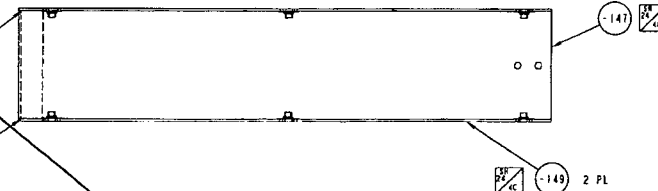


② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500

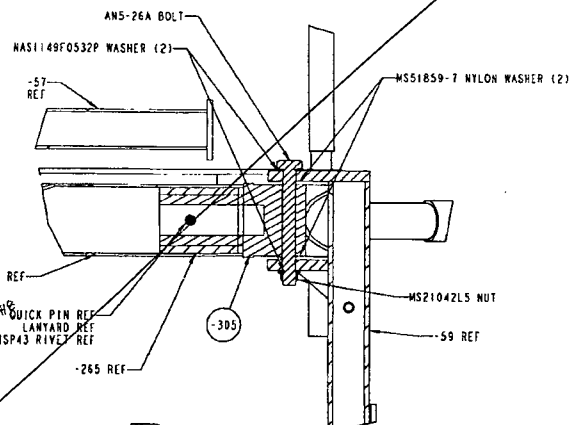



Q. 13  
(2 marks)



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



DETAIL A   
SCALE 0.750  
(-03 ASSY)

<b>PREMIER AVIATION, INC</b>			
2021 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	RENT NO.	DMG ID.
D	OSUV8	867-43001	
SCALE:			

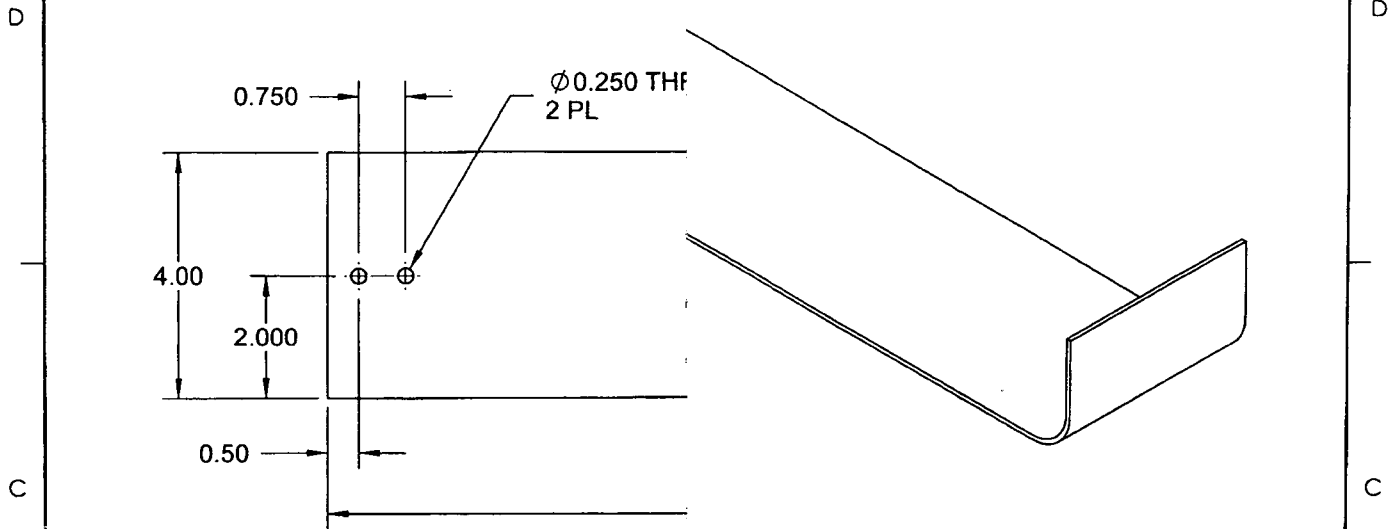
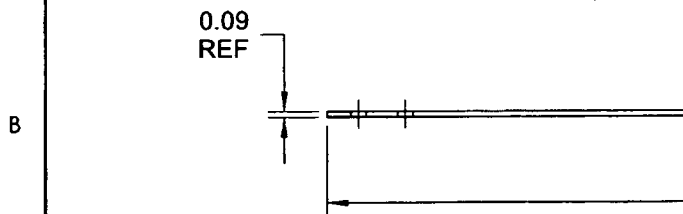
**ORIGINAL**

8

7

2

1

**B67-4**

#52434  
**RELEASED**  
 2009-09-21  
 MND

PREMIER AVIATION DRAWING IAW DART QSI  
 3. FOR PREVIOUS REVISIONS, REFER TO  
 PREMIER AVIATION DRAWING No.  
 REASON: SEE PAR#09-011.

MB

09.03.03

DESCRIPTION

BY

DATE

**NOTES:**

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM  
 PER AMS-QQ-A-250/11 OR AMS 402  
 REF. DART SPEC. M6061T6S.090

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.74 lbs

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**B67-43001-147**

REV. C

SHEET 1 OF 1

TITLE

**SUPPORT PLATE**

SCALE

NTS

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8

7

2

1

# Work Order ID 52639

October 5, 2009 11:32:02 AM



Page 1

Item ID: PB67-43001-147

Accept



Setup Start



Revision ID: C

Item Name: Support Plate

Stop



Start Date: 10/05/2009 Start Qty: 27.00



Cust Item ID:

Required Date: 10/08/2009 Req'd Qty: 27.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 09-10-05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001	C
-----------	---

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg PB67-43001-147

Dwg Rev: \_\_\_\_\_

Prog Rev: \_\_\_\_\_

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

REFERENCE ONLY

**Work Order ID 52639**

October 5, 2009 11:32:02 AM



Page 2

Item ID: PB67-43001-147

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support Plate

Start Date: 10/05/2009 Start Qty: 27.00



Cust Item ID:

Required Date: 10/08/2009 Req'd Qty: 27.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							
130  Brake NC Brake NC	Bend as per dwg  Memo	0.00  0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							

REFERENCE ONLY

# Work Order ID 52639

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Item ID: PB67-43001-147

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support Plate

Start Date: 10/05/2009 Start Qty: 27.00



Cust Item ID:

Required Date: 10/08/2009 Req'd Qty: 27.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Identify as per dwg & Stock Location: <u>ST.</u>	0.00							
Packaging	Memo	0.00							
Packaging									
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

See w/o #52434 pulled on 27 parts on new w/o (couldn't change part number in old w/o)

27

MF 09-10-05

REFERENCE ONLY

# Picklist Print

Page 1

October 5, 2009 11:32:02 AM

Work Order ID: 52639



Parent Item: PB67-43001-147RevB1



Parent Item Name: Support Plate

Start Date: 10/05/2009

Required Date: 10/08/2009

Comments:

Start Qty: 27.00

Required Qty: 27.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased	No			100	sf	114.8403	16.9731			



6061-T6 .090 Sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	114.8403	
108595	1.41	
109184	16.3403	
111382	96	
19295	1.09	

already pulled

PB6743001-67.

27 x B-52434

mk 09-10-05

REFERENCE ONLY